

Work Order ID 125479

October-09-14 7:33:36 AM

*Rush*

\*125479\*

Page 1

Item ID: D4131-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Doubler Assy  
 Start Date: 10/09/14 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 10/17/14 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: *W* Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4131	B								
100	FLOW WATER JET	0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D4131-7 as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

⑧ 12/02/14/10/09

⑧ 12/02/14/10/09

⑧ 14-10-10  
 DAS  
 38  
 9-89

**Work Order ID 125479**

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Item ID: D4131-043

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Doubler Assy

Start Date: 10/09/14 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 10/17/14 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

**\*130\***

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

COUNTER SINK AS PER DWG

Deburr if necessary.

8X

14/10/14

DAS  
36  
9-89

150

**\*150\***

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

8

DAS  
38  
9-89

14-10-14

160

**\*160\***

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

8

φ

14-10-14



# Work Order ID 125479

**\*125479\***

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**Item ID:** D4131-043 **Accept** **\*N900040100\*** **Setup Start \*NS1\***  
**Revision ID:** **Stop \*NS2\***  
**Item Name:** Doubler Assy  
**Start Date:** 10/09/14 **Start Qty:** 5.00 **\*5\*** **Cust Item ID:**  
**Required Date:** 10/17/14 **Req'd Qty:** 5.00 **\*5\*** **Customer:**  
**Reference:**

**Approvals:** **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Run Start \*NR1\***  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Stop \*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>st 093</u>	0.00							
<b>*180*</b>									
Packaging	Memo	0.00				(8)		MLJ	14-10-16
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							14/10/17 JJ
Quality Control									

(4-10-16)

# Picklist Print

October-09-14 7:33:36 AM

Page 1

Work Order ID: 125479

**\*125479\***

Parent Item: D4131-043

**\*D4131-043\***

Parent Item Name: Doubler Assy

Start Date: 10/09/14

Required Date: 10/17/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

891.5011

0.1807

1

**\*M6061T6S 063\***

6061-T6 .063 Sheet

**\*\***

De 14/10/09

Location

Loc Qty

Loc Code

MAT021

688.5011

M127420

111.12

M128054

56.89

M128941

17.04

M129636

181.1511

M129845

76.5

M129881

116

M130096

129.8

TPI

203

M129637

203

MS20426AD3-3

Purchased

No

165

Each

3,151.000

8

40

**\*MS20426AD3-3\***

RIVET

**\*\***

14/10/15

DAS  
36  
9-89

Location

Loc Qty

Loc Code

ST315

3151

123352

312

M128754

2839

64

# Picklist Print

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Work Order ID: 125479

Parent Item: D4131-043

Parent Item Name: Doubler Assy

**\*125479\***

**\*D4131-043\***

Start Date: 10/09/14

Required Date: 10/17/14

Start Qty: 5.00

Required Qty: 5.00

MS21069L3

Purchased

No

165

Each

52.0000

4

20

**\*\***

DAS  
36  
9-8

**\*MS21069L3\***

ANCHOR NUT

14/10/15

Location

Loc Qty

Loc Code

ST303

52

m127813

2

m128650

1

m128818

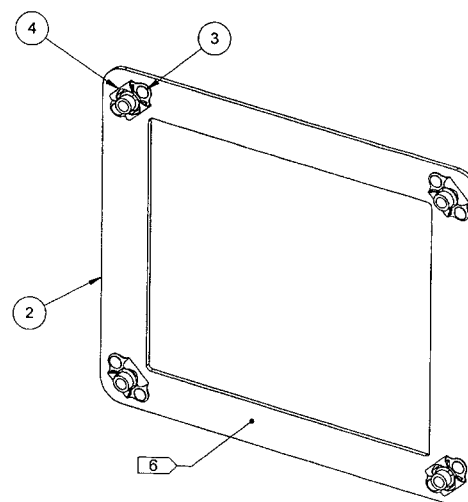
35

m129472

14

32

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4131-043	DOUBLER ASSEMBLY
2	1	D4131-7	DOUBLER
3	8	MS20426AD3-3	RIVET
4	4	MS21069L3	NUT PLATE



WLO 125479

**D4131-043 DOUBLER ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

**RELEASED**  
2011-09-21

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4131	SHEET 2 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MANIFOLD ASSEMBLY	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	





DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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